












Date: Monday, 22/09/2008 1:03:36 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 42174		
Estimate Number	: 10517		
P.O. Number	:	Part Number	: D28061
This Issue	: 22/09/2008 S.O. No. :	Drawing Number	: D2806 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 39057	Material	:
Written By	:	Due Date	: 29/09/2008
Checked & Approved By	: <u>JUL 08.9.22</u>	Qty:	50 Um: Each
Comment	: Est:B 05.03.11 Part now turned KJ/JLM Est Rev:C Now on Doosan Lathe JLM Verified By:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6H1000	6061-T6 HexBar 1.00	
			
Comment: Qty.: 0.0962 f(s)/Unit Total : 4.8090 f(s) 6061-T6 Hex Bar 1.0" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar (M6061T6H1.000) Batch: <u>M109478 SA 08/11/11</u> <u>4pt</u>			
2.0	DOOSAN LATHE	DOOSAN LATHE	
			
Comment: Doosan Lathe 1- Turn as per Folio FA105 Rev: <u>NA</u> & Dwg D2806 Rev: <u>A</u> 2-Deburr per dwg D2806 <u>SA 08/11/11</u> <u>SC</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SA 08/11/11</u> <u>SC</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>JL 08/11/11</u>			
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <u>M-1 08/11/12</u> <u>SOX</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 42174

Part Number: D28061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



sl



Comment: INSPECT ALODINE

08-11-12

(x 50)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *48*

8/11/12

(50x)

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/13

Job Completion



u 08.11.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42174
Description: Bushing		Part Number: D2806-1
Inspection Dwg: D2806	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

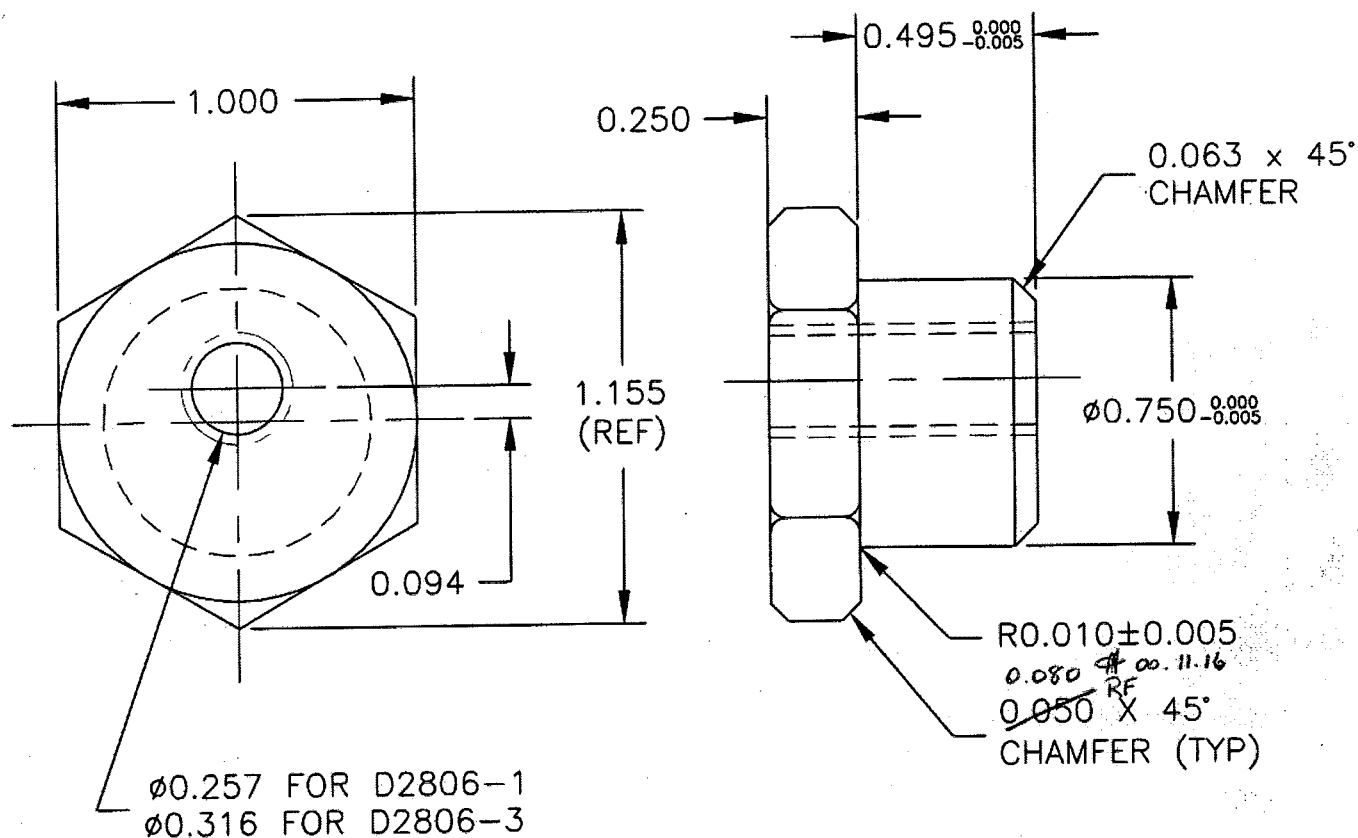
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.001	✓			
1.155	+/-0.010	1.152	✓			Acceptable. It's the material thickness.
0.250	+/-0.010	0.254	✓			
0.063 x 45°	+/-0.010	0.063 x 45°	✓			
0.080 x 45°	+/-0.010	0.080 x 45°	✓			
0.495	+0.000/-0.005	0.491	✓			
0.750	+0.000/-0.005	0.748	✓			
Ø0.257	+0.005/-0.000	Ø0.258	✓			
0.094	+/-0.010	0.094	✓			

Measured by: SA	Audited by: JL	Prototype Approval:	N/A
Date: 08/11/11	Date: 08/11/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	08.01.16	0.094 dimension added	KJ/EC/DD	

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13 #

D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42119

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